

Work Order ID 83810

83810

Page 1

April-26-12 12:39:58 PM

Item ID: D2493

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Patient Stop Assembly

Stop *NS2*

Start Date: 26/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2493

Rev B

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D2493.

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location 8221

0.00

120

Packaging

Memo

0.00

Packaging

DAS
16
14

12/04/23

5x

12/07/23

5x

12-7-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item Name: Patient Stop Assembly

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/7/24

MF 12-07-24

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Picklist Print

April-26-12 12:40:02 PM

Page 1

Work Order ID: 83810

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Parent Item: D2493

D2493

Parent Item Name: Patient Stop Assembly

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C03.01.17Reformat; Incorporated D2492KJ/RFIPP Rev:D
10.09.24 as per revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2492		Manufactured	No			100	Each	0.0000	1	4			
D2492						79479	52		**			12/07/23	
Patient Stop													
D2444		Manufactured	No			100	Each	19.0000	2	8			
D2444									**			12/07/23	
Pip Pin Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST009		3							
				80060		3							
				ST019		16							
				79477		16							
MS27039-1-07		Purchased	No			100	Each	78.0000	2	8			
MS27039-1-07									**			12/07/23	
Screw													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST291		78							
				18106		78							

B8635834
B8600022

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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April-26-12 12:40:02 PM

Page 2

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Parent Item: D2493

D2493

Parent Item Name: Patient Stop Assembly

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

100

Each

3,314.000

2

8

NAS1149D0363.J

Washer

**

Handwritten signature
10/07/23

Location

Loc Qty

Loc Code

ST298

3314

117601

61

118077

1

118612

18

119537

33

120142

55

120308

46

120644

232

121243

1368

121524

1500

MS21042L3

Purchased

No

100

Each

3,266.000

2

8

MS21042L3

Nut

**

Handwritten signature
10/07/23

Location

Loc Qty

Loc Code

ST300

3266

117441

16

117885

32

118451

5

118927

3

119017

1196

119075

158

121349

856

121444

1000

Handwritten signature
M122452

April-26-12 12:40:02 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

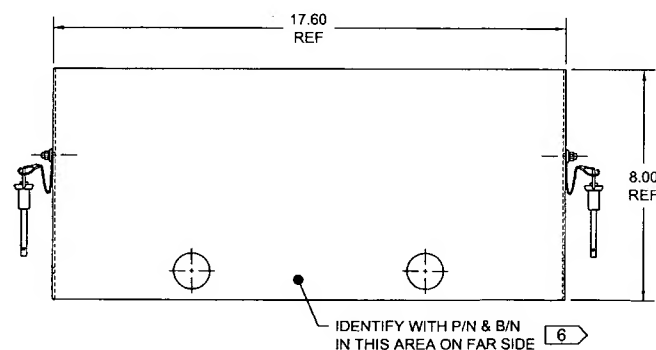
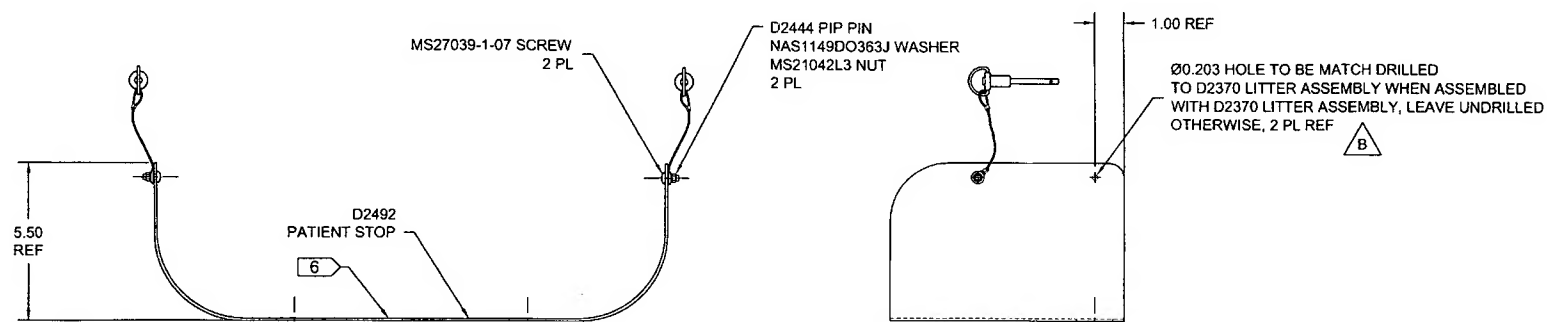
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ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D2493	PATIENT STOP ASSEMBLY
2	1	D2492	PATIENT STOP
3	2	D2444	PIP PIN
4	2	MS27039-1-07	SCREW
5	2	NAS1149DO363J	WASHER (OR AN960JD10)
6	2	MS21042L3	NUT (OR MS21042-3)



D2493 PATIENT STOP ASSEMBLY

NOTES:

- 1) MATERIAL: SEE PARTS LIST
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2493" AND B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 1.7 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83810 MLC
12/04/26

RELEASED
2010-09-21

B	REDRAW, HOLE NOW DRILLED (D2-1, NCR10-062)	CP	10.08.10
A	NEW ISSUE	BW	95.10.24
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D2493	SHEET 1 OF 1
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	PATIENT STOP ASSEMBLY	NTS
DATE	10.08.10	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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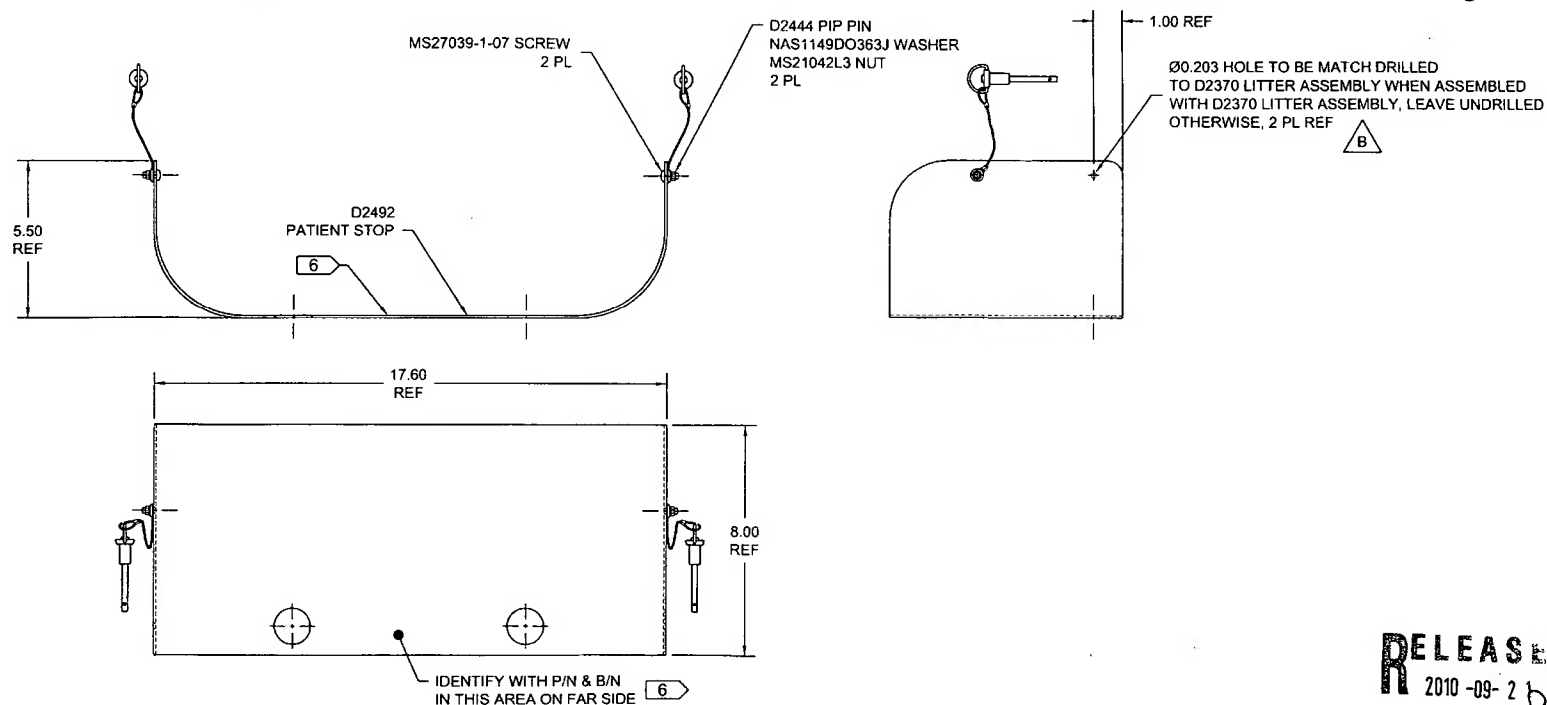
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MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	10.08.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D2493

REV. B

SHEET 1 OF 1

TITLE

PATIENT STOP ASSEMBLY

SCALE

NTS

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